

# Work Order ID 53702

November 12, 2009 3:03:04 PM

Page 1

Item ID: D3049-1

Accept

Setup Start

Revision ID: A1

Stop

Item Name: Bearpaw

Start Date: 11/12/09 Start Qty: 8.00

Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3049

Rev A1

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1  
3-Deburr

BLANKS

8 9-11-20

M.A 09/11/21

8

130

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

M.A 09/11/21

8

8

140

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/05/11/22

8 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53702

November 12, 2009 3:03:04 PM



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Item ID: D3049-1

Accept



Setup Start



Revision ID: A1

Item Name: Bearpaw

Stop



Start Date: 11/12/09 Start Qty: 8.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PPR  
53695

0.00

Packaging

Packaging

PC 911/23 (8)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.11.23

u 09.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

November 12, 2009 3:03:03 PM

Work Order ID: 53702



Parent Item: D3049-1RevA1



Parent Item Name: Bearpaw

Start Date: 11/12/09

Required Date: 11/20/09

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	539.8629	27.2000	40.		



UHMW 1" Black



B 9-11-20

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	497.7752	
112186	126.5752	
112514	51.2	
113166	320	
Main Warehouse		
ST	42.0877	
111354	42.0877	

112514

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D3049-1
<b>Inspection Dwg:</b> D3049 <b>Rev:</b> A1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	Ø0.260	✓			
B	0.93	+/-0.030	0.925	✓			
C	0.40	+0.030/-0.000	0.410	✓			
D	2.00	+/-0.030	2.000	✓			
E	10.250	+/-0.010	10.250	✓			
F	4.540	+/-0.030	4.538	✓			
G	5.88	+/-0.030	5.884	✓			
H	0.38	+/-0.030	0.382	✓			
I	11.50	+/-0.030	11.50	✓			
J	0.07 x 45°	+0.030/-0.010	0.060x45°	✓			
K	0.44 - 0.47	+/-0.000	0.449	✓			
L	R0.25	+/-0.030	R0.250	✓			
M	0.38	+/-0.010	0.388	✓			
N	0.95	+0.030/-0.010	0.975	✓			
O	0.69	+/-0.030	0.690	✓			
P	0.20	+/-0.030	0.215	✓			
Q	23.00	+/-0.030	23.000	✓			
R	0.25 x 45°	+/-0.030	0.246x45°	✓			

<b>Measured by:</b> M.A.	<b>Audited by:</b> JH	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/11/22	<b>Date:</b> 07/11/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	[Signature] RF 03.01.13	Ø 0.73 WAS Ø 0.75	

RELEASED  
67-10-24

[illegible]

D3049-1 BEARPAW

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,  
1.00" THICK (MACHINE TO 0.950)

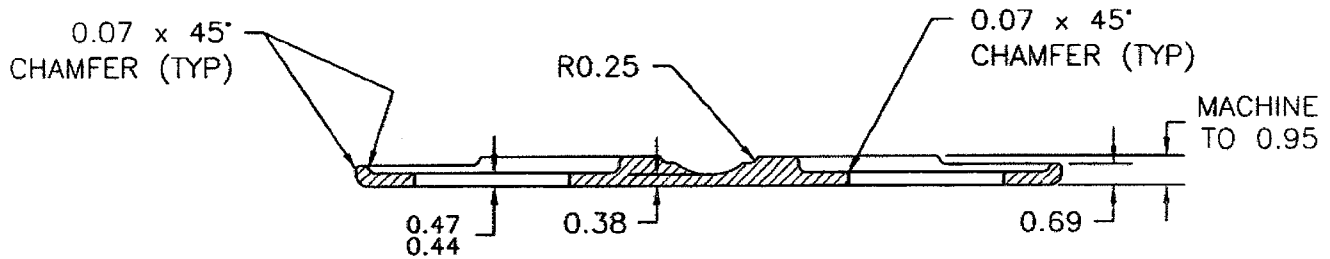
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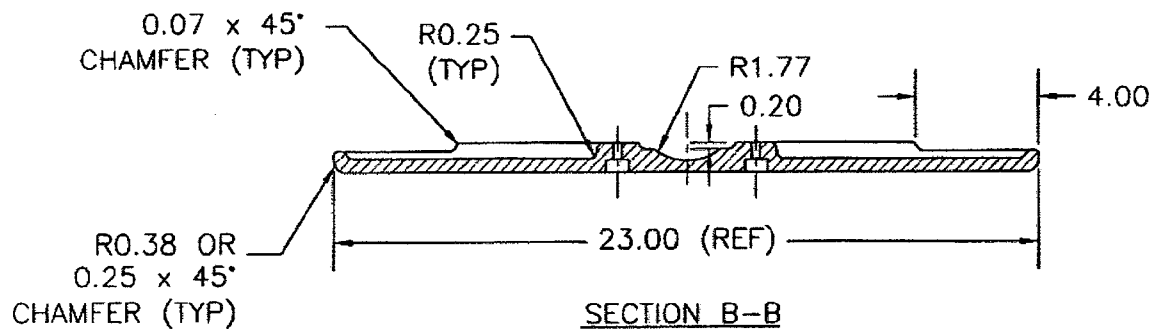


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED  
01.10.24 H



SECTION A-A



SECTION B-B

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